

5/15

DART AEROSPACE	Work Order:	22852
Description: Mounting Bracket	Part Number:	D2581
04.06.25 UP 04.06.25		
Drawing: D2581 Rev. A1	Qty:	52 54

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	KD	05/03/28	52
2	PURCHASING	Issue P/O: <u>2007800</u> Laser cut as per Dwg D2581 Material: 304/316 SS 0.125" thick Material release note required	U	05/03/28	52
3	RECEIVING	Receive and Inspect for transit damage Ensure material release note attached	CL	05/04/26	54
4	QC	Inspect Level 6	SB	05/05/02	54
5	METAL	Deburr	SB	05/05/02	54
6	METAL	Form as per Dwg D2581 using CNC Brake	SB	05/05/02	54
7	QC	Inspect Level 5	2	05-05-103	54
8	STORES	Identify and Stock	CL	05/05/04	54
9	EXPEDITING	Close W/O Cost / Part: <u>3.95</u> <u>540</u> <u>05/15/05</u> (54) 9.01	HA	05.05.10	54

Rev	Date	Change	Revised By	Approved
B	98.01.14	Add Inspection Level and Dwg Ref	BW	
C	99.06.29	Re-format	DM	
D	01.07.17	Added info to step 2	SM	EC

RELEASED

EC 01-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

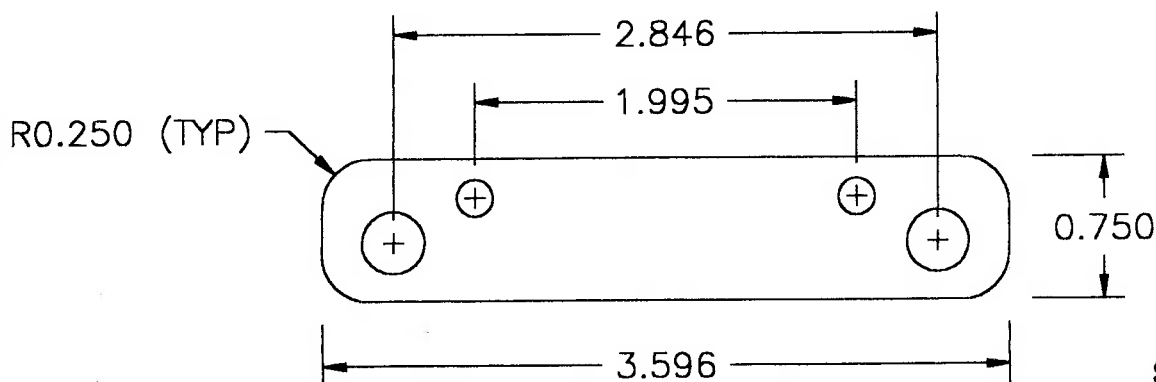
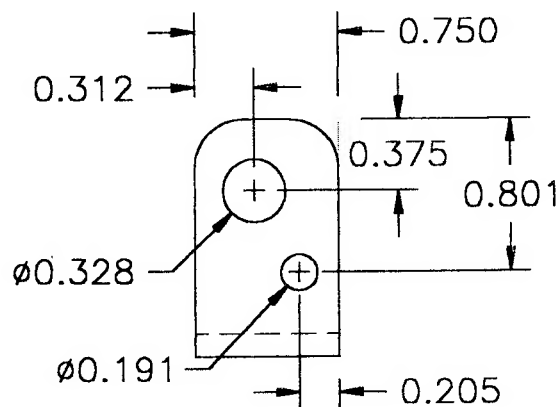
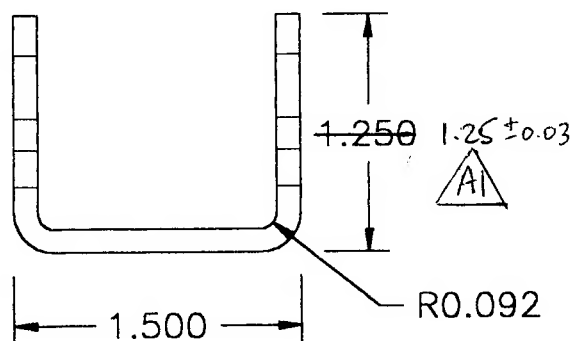
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO. D2581	REV. A
CHECKED <i>BW</i>	APPROVED <i>M.M.</i>		SHEET 1 OF 1
DATE 96.06.27		TITLE MOUNTING BRACKET	SCALE 1:1
AI	CP 04.05.14	CHANGE TOLERANCE ON 1.25 DIMENSION	

RELEASED
96/07/23 BW



MATERIAL: 304/316 SS 0.125 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22852

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 24, 2005
08:41 am

Work Order No : 0022852

Project Name : D2581

Project For : WK515

Work Order Type : Main

Main WO Number :

House Part Number : D2581

Description : Mounting Bracket

Manufactured : Yes

Amount Req'd : 52

Amount Done : 0

Start Date : 03-24-05

Est Finish Date : 04-15-05

Act Finish Date :

Drawings Req'd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000%

Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

902515416

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES


 INVOICE NO.:
 COMMODITY:

 FORM 575
 PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304NO.4 SEC
 FINISH WITH 180 MESH FILM ON MAIN SIDE, WITH BACK PASS,
 SLITTED EDGE AISI 304.2B FINISH, WITH PAPER INTERLEAVED,
 SLITTED EDGE

SPECIFICATION:

CUSTOMER:

 AISI 304
 INTEGRIS METALS LTD

 1. 廠址: 臺灣桃園市觀音區
 345, SHUN AN RD., LI CHU HSIANG
 KAOHSIUNG TAIWAN R.O.C.
 TEL: 887-8672888 FAX: 887-8673008
 CERTIFICATE NO: 3307282
 DATE OF ISSUE: 07222004

CUSTOMER :		ENT 30018 METALS LTD																
(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL-50 mm					Chemical Composition (%)							
		KGS	LBS			YS	TS	EL	HRB	HV	C	Si	Mn	P	S	N	O	H
						(MPa)	(MPa)	(%)			x100	x100	x100	x100	x1000	x100	x100	x100
AISI 304 NO.4 SEC (7487-7186)																		
11GA46"X130"	1	1.382	3.069	YU229445	36S26735A-115	301	858	50	85	172	4	48	123	25	8	885	1818	2
11GA46"X130"	1	1.382	3.069	YU229445	36S26735A-118	301	858	50	85	172	4	48	123	25	8	885	1818	2
11GA46"X130"	1	896	1.992	YU229445	36S26735A-117	301	858	50	85	172	4	48	123	25	8	885	1818	2
(7487-7177)																		
11GA46"X130"	1	1.381	3.067	YU229445	36S26735A-112	301	858	50	85	172	4	48	123	25	8	885	1818	2
11GA46"X130"	1	1.383	3.071	YU229445	36S26735A-113	301	858	50	85	172	4	48	123	25	8	885	1818	2
11GA46"X130"	1	1.383	3.071	YU229445	36S26735A-114	301	858	50	85	172	4	48	123	25	8	885	1818	2
(7487-7188)																		
11GA46"X130"	1	1.423	3.137	YU132352	35S23506C-112	311	861	52	85	178	4.8	51	109	28	4	811	1828	2.3
7		8.079	20.016															
NO MERCURY CONTAMINATION		Send test card for all Heat NO.																

Periodic

NO MERCURY CONTAMINATION

Dead test good for all Heat NO.

 THE BUYER CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
 BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE

 PRODUCT IN ACCORDANCE WITH ASTM A240, A284,
 A282E, ASME SA240, QQ36766D.

YIEH MAU CORP.

 Lin Kim Hsing
 Manager of Quality Assurance Section